71662

Page 1

Accept

N900040100

Date:

Date:

Setup Start

Stop *NS2*

Cust Item ID: Customer:

Date: Date:

Tooling:

SPC (Y/N):

Run

Start

Stop

Sequence ID/ Work Center ID Operation Description

Large Fab

Set Up/ Run Hours Tool ID

Tool# Plan Code

Accept Reject Oty Oty

Reject Insp. Number Stamp

Draw Nbr

Revision Nbr

D3255 100

Large Fab

Large Fab

Rev B

100

Memo

0.00

0.00

1-Weld as per Dwg D3255 ***purge weld***A/R Batch: 115778 2-Grind Welds Flush

SS ROD

110

QC10- Inspect visual per QSI004- ground welds

0.00

110

OC

Memo

0.00

Cpl 11.10.19

Quality Control

120

QC.

QC5- Inspect part completeness to step on W/O

Sulolia

120

Quality Control

Memo

W/O:			WO	RK ORDER CHANGI	S		Tá.	
DATE	STEP	PRO	CEDURE CHAP	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	OTED	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

October-14-11 11.46:30 AM Item ID: D3255-041 Revision ID: Access Panel Assembly Item Name: Start Date: 7/07/11 Required Date: 7/21/11 Reference:

Accept

N900040100

Setup Start

Start Qty: 4.00 Req'd Qty: 4.00

Cust Item ID: Customer:

Approvals: Process Plan: Date:

Tooling:

0.00

Date:

Start Run

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

Operation Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Set Up/ Run Hours Tool ID

Tool # Plan Code Accept Otv

Qty

Reject Reject Number Stamp

Insp.

130

130

140

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

140

Memo

QC3- Inspect Part Finish

0.00

0.00

Quality Control

0.00

150

Small Fab

Memo

0.00

Small Fab Small Fab

150

1-Bond D3255-5 gasaket to d3255-041 using Dow corning adhesive as per Dwg DOW CORNING ADHESIVE

	oopaco.							
N/O:			WO	RK ORDER CHANGE	S			
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Page 3

October-14-11 11:46:30 AM

Item ID:

D3255-041

Revision ID:

Item Name: Access Panel Assembly

Start Date: Required Date: 7/21/11

7/07/11

QC:

Start Qty: 4.00 Req'd Qty: 4.00

Operation

Description

4

Cust Item ID:

N900040100

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

Accept

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Tool#

Plan

Code

Run

Setup Start

Sequence ID/ Work Center ID

160

160

QC5- Inspect part completeness to step on W/O

0.00

Dululos

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

Quality Control

Memo

170

170

Packaging Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

180

180

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

11/11/8 18 1 0°6

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Picklist Print

October-14-11 11:46:30 AM

Work Order ID:

71662

Parent Item:

D3255-041

Parent Item Name:

Access Panel Assembly

Start Date: 7/07/11

Required Date: 7/2 //11

Start Qty; 4.00

Required Qty: 4.00

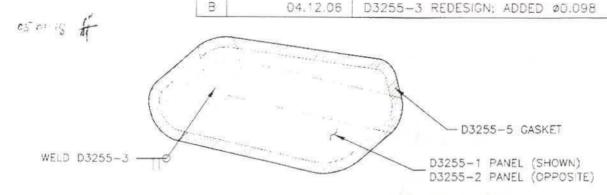
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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-1 Panel		Manufactured	No			100	Each	6,0000	1	4	1.1	1	,
				<u>Location</u> WA		Loc Qty	1.0	e Code		1	25 11	10/	18
D3255-3 Cap		Manufactured	No	7163 7219		2 4 150	Each	14.0000	_@	4	Px		
D3255-5				Location WA 7215	52	Loc Qty 14 14	Lo	c Code	(2)	11.4	Sy	11/10	/18
Gasket		Manufactured	No	Location		Loc Qty	Each	9,0000 c Code	1 (4	01	1	1
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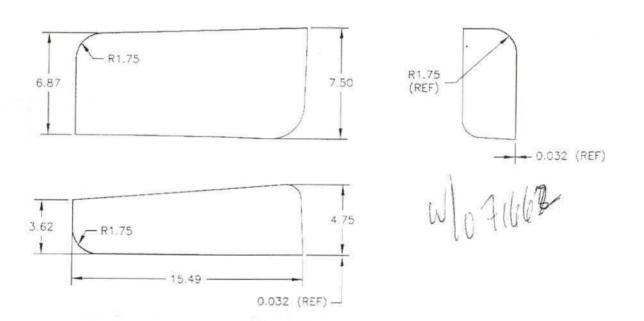
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04.12.0	6	TITLE ACCESS PANEL ASSEMBLY	SCALE 1.5
А	04.01.27	NEW ISSUE	
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D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL D3255-2 OPPOSITE

- D3255-041/-042 NOTES:

 1) WELD PER DART QSI 004

 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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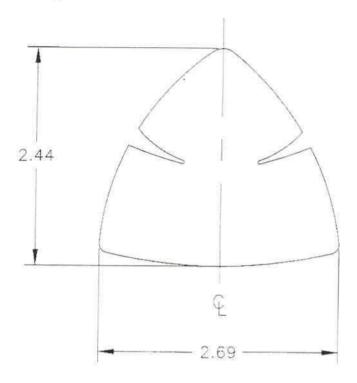
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DATE		TITLE	SCALE
04.12.06		TITLE	111





D3255-3 CAP FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (RCF. M304S22GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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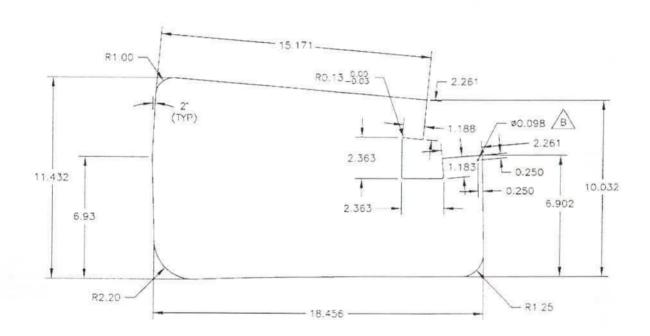
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D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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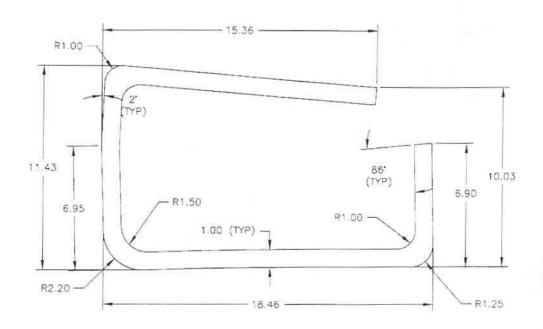
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D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

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